

Work Order ID 58503

Friday, May 07, 2010 2:30:28 PM



Page 1

Item ID: D3908-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Lug Assembly, Aft

Start Date: 5/10/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 5/13/2010 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan: *mf*

Date: *10-5-7*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3908

B

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

EP 10/05/12 (6)

110

0.00



Small Fab

Memo

0.00

Small Fab

1- Assemble as per dwg
TRIM RIVETS 1.185" LONG

EP 10/05/12 (6)

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Siolusla

(+6)

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)					
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Packaging

Identify as per dwg & Stock Location: 476

0.00

Memo

0.00

Packaging

10-5-12 (Signature)

140



QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Quality Control

10/05/13 (Signature)
MF
10-5-12

W/O:			WORK ORDER CHANGES					
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Picklist Print

Friday, May 07, 2010 2:30:28 PM

Page 1

Work Order ID: 58503

Parent Item: D3908-041

Parent Item Name: Crosstube Lug Assembly, Aft

Comments: IPP RevA: New issue DD verified by:EC
As per Rev B 10-04-06 VERIFIED BY:DD





IPP REVB:

Start Date: 5/10/2010

Required Date: 5/13/2010

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D2690-6  Lanyard Assembly		Manufactured	No			100	Each	0.0000	1		5/10/05/12	
D3908-1  Lug Plate, Aft Crosstube		Manufactured	No			100	Each	35.0000	2		5/10/05/12	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				ST095		35						
				57815		7						
				58344		28						
D3908-3  Stud Receiver, Lower		Manufactured	No			100	Each	2.0000	1		5/10/05/12	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				ST095		2						
				57816		2						
D3908-5  Eyebolt Stud		Manufactured	No			100	Each	13.0000	1		5/10/05/12	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				GA		1						
				57428		1						
				ST095		12						
				58347		12						

B58375 @

B58345 @

7
5

6

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Parent Item Name: Crosstube Lug Assembly, Aft

Comments: IPP RevA: New issue DD verified by:EC
As per Rev B 10-04-06 VERIFIED BY:DD

IPP REV B:

Start Date: 5/10/2010

Required Date: 5/13/2010

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D3910-1 Crosstube Lug		Manufactured	No			100	Each	12.0000	2		5/10/05/12	

Location	Loc Qty	Loc Code
ENG	11	
57194	11	
st507	1	
58353	1	

AN3C12A Bolts	Purchased	No			100	Each	176.0000	4		5/10/05/12	
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Location	Loc Qty	Loc Code
ST351	176	
112314	176	

MS17984-C413 PIN, QUICK RELEASE	Purchased	No			100	Each	27.0000	1		5/10/05/12	
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Location	Loc Qty	Loc Code
ST297	4	
114340	4	
ST314	23	
114495	3	
114523	20	

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Shop Packet Print

Page 2

W/O:			WORK ORDER CHANGES					
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As per Rev B 10-04-06 VERIFIED BY:DD

IPP REVB:

Start Date: 5/10/2010

Required Date: 5/13/2010

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
MS20615-4M20 RIVET	4M18	Purchased	No			100	Each	204.0000	6		5/10/05/12	

Location	Loc Qty	Loc Code
ST323	204	
113254	16	
114324	4	
114349	184	

MS21043-3 Nut		Purchased	No			100	Each	3,735.000	4		5/10/05/12	
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Location	Loc Qty	Loc Code
FG	80	
103691	80	
ST301	3655	
112314	3655	

NAS1149C0332R Washer		Purchased	No			100	Each	3,238.000	8		5/10/05/12	
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Location	Loc Qty	Loc Code
ST297	3238	
113524	10	
113737	150	
114341	3078	

Friday, May 07, 2010 2:30:28 PM

Shop Packet Print

Page 3

W/O:			WORK ORDER CHANGES					
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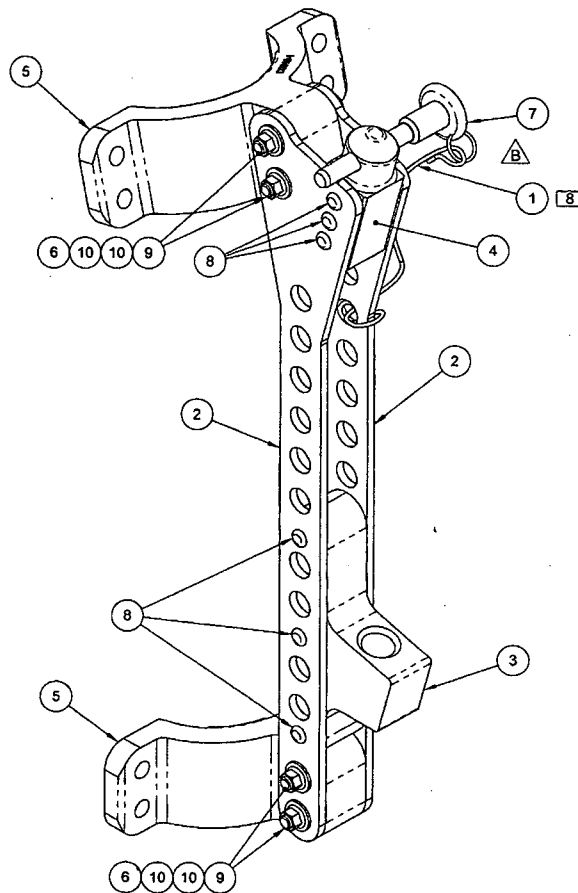
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ITEM	QTY.	P/N	DESCRIPTION
	X	D3908-041	X-TUBE LUG ASSY (AFT)
1	1	D2690-6	LANYARD
2	2	D3908-1	AFT X-TUBE LUG PLATE
3	1	D3908-3	STUD RECEIVER LOWER
4	1	D3908-5	EYEBOLT STUD
5	2	D3910-1	X-TUBE LUG
6	4	AN3C12A	BOLT
7	1	MS17984-C413	PIP PIN
8	6	MS20615-4M20	RIVET
9	4	MS21043-3	NUT
10	8	NAS1149C0332R	WASHER



D3908-041 X-TUBE LUG ASSY (AFT)

RELEASED
2010-04-14
MP

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3908-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.35 lbs
- 8) ATTACH TO D3908-1 BY LOOPING AROUND LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413 PIP PIN'S RING.

B	BOM: D3908-5 REPLACED WITH D3908-5. QTY 1 ADDED: D2690-6 & MS17984-C413. SHEET 5: ADDED D3908-5	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH	DRAWING NO. D3908	
CHECKED	JPH	SHEET 1 OF 5	
MFG. APPR.	JPH	TITLE X-TUBE LUG ASSY (AFT)	
APPROVED	JPH	SCALE NTS	
DE APPR.	JPH	DATE 10.04.06	
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W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

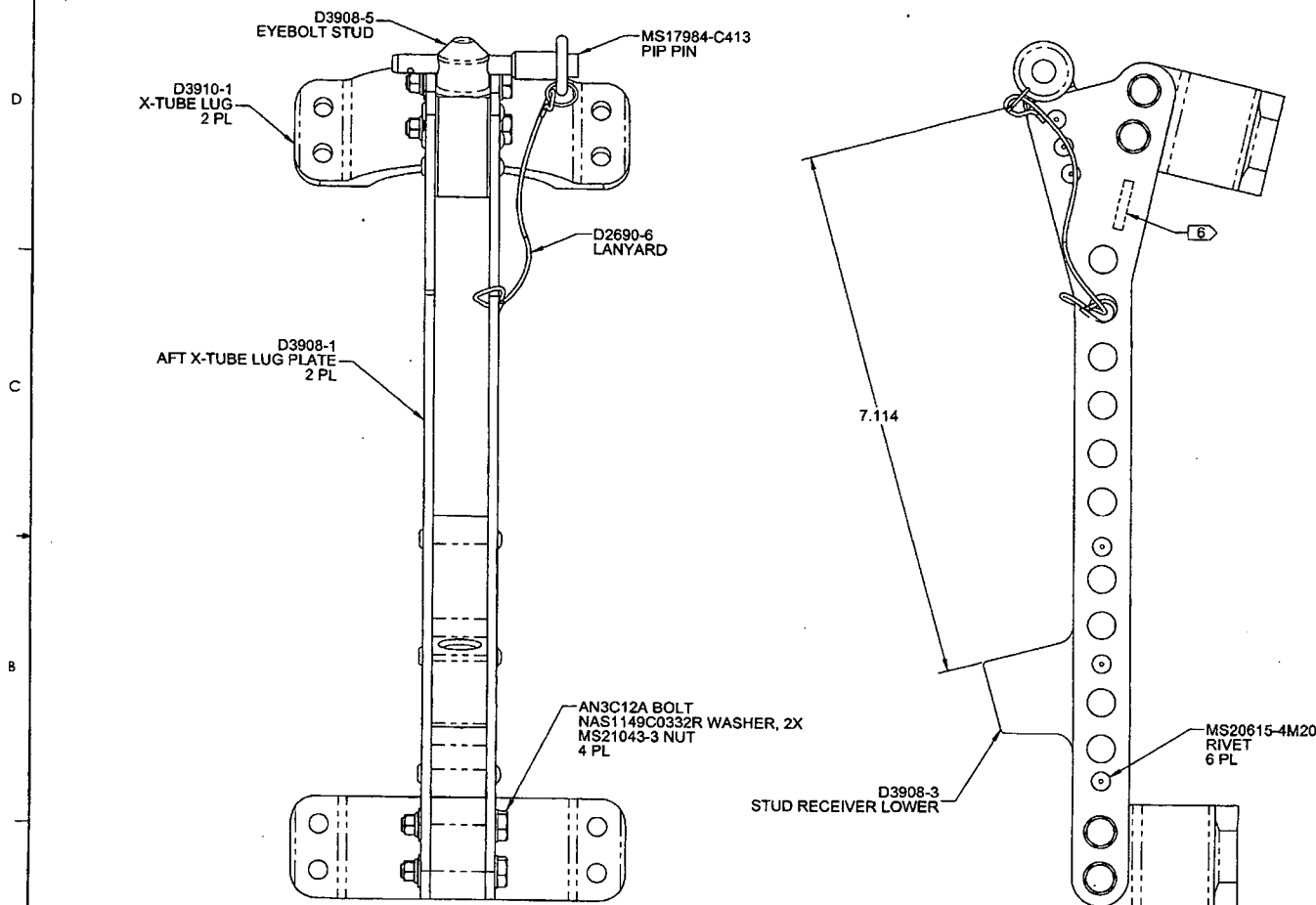
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NCR:			WORK ORDER NON-CONFORMANCE (NCR)					
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D3908-041 X-TUBE LUG ASSY (AFT)

RELEASED
2010-04-14
MP

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO. D3908	REV. B
MFG. APPR.	<i>[Signature]</i>	TITLE X-TUBE LUG ASSY (AFT)	SHEET 2 OF 5
APPROVED	<i>[Signature]</i>	SCALE NTS	
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DATE	10.04.06		

8 7 6 5 4 3 2 1

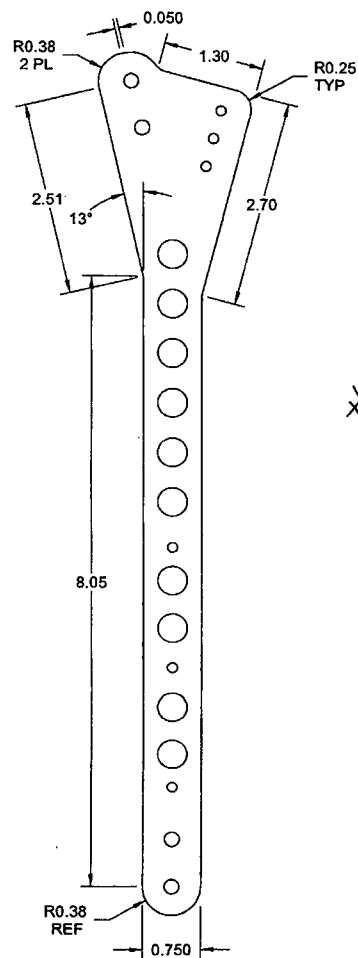
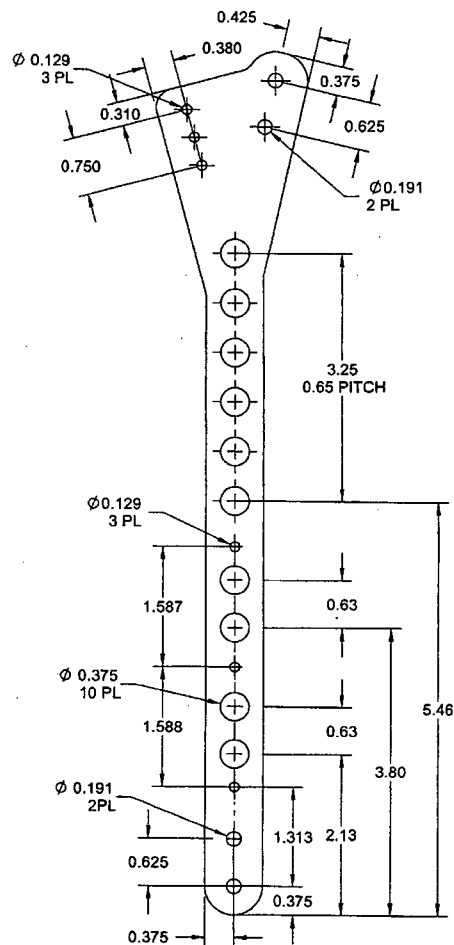
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



#58503

RELEASED
2010-04-14
MD

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 PER DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.32 lbs

D3908-1 AFT X-TUBE LUG PLATE

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JPH	DRAWING NO.	REV. B
MFG. APPR.	JPH	D3908	SHEET 3 OF 5
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	X-TUBE LUG ASSY (AFT)	NTS
DATE	10.04.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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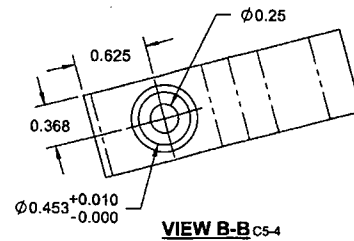
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DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

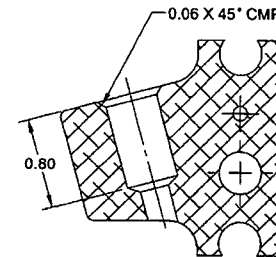
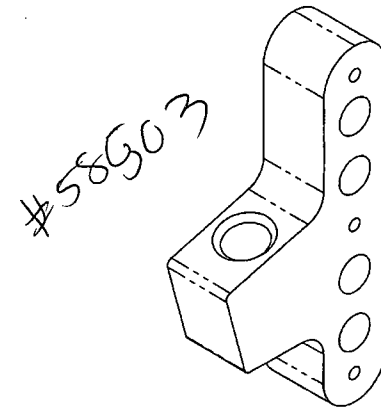
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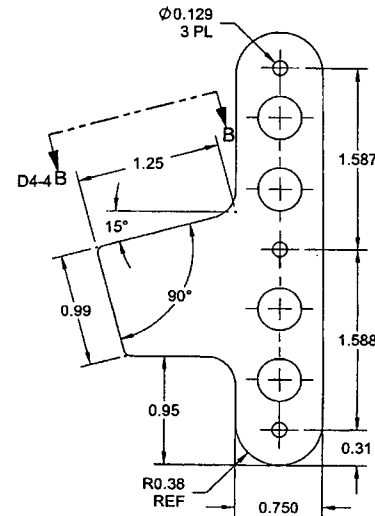
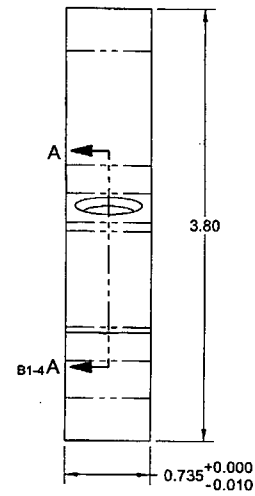
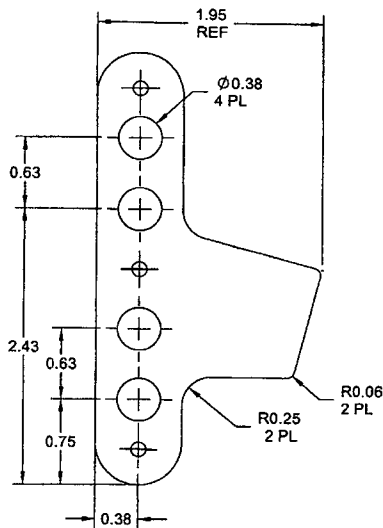


VIEW B-B CS-4



SECTION A-A B6-4





RELEASED
2010-04-14
mp



D3908-3 STUD RECEIVER LOWER

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276
PER DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.69 lbs

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3908	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		X-TUBE LUG ASSY (AFT)	NTS
DATE	10.04.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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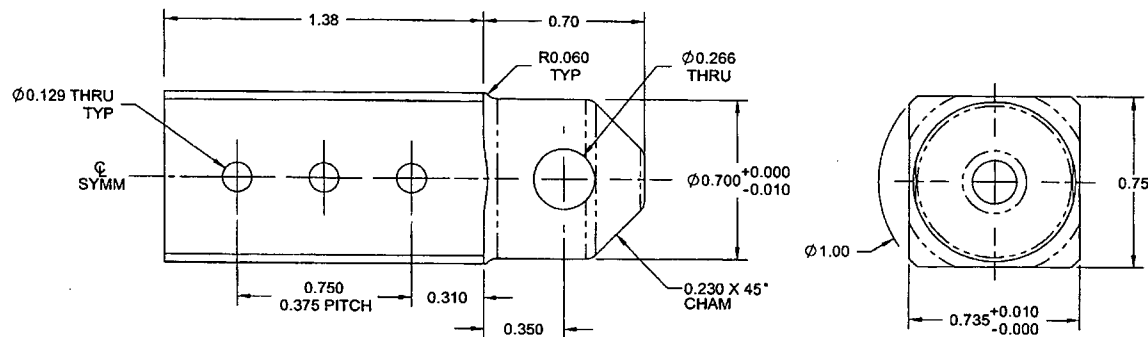
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NOTE: Date & initial all entries



D3908-5 EYEBOLT STUD



RELEASED
2010-04-14
MP

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582 PER DART SPEC M303R OR M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.26 lbs

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JPH	DRAWING NO. D3908	REV. 8
MFG. APPR.			SHEET 5 OF 5
APPROVED		TITLE	SCALE
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